-

DQA:_	Date:	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

							, c.		QA Closed:	Dat	te:
Work Orde	 r:			<u>-</u>	DISPOSITION			AGAINST DE	PARTMENT,	/PROCESS	
Part N					Rework Scrap Use-as-is		Skid-tube Machining ermoforming	Crosstube Small Fab Finishing	i	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	0		·		Work Order Update] '''	Large Fab	Composite	Nec/3tol	Supplier	
Root				Descri	ption of work order update	Initia	I A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ing Desc	cription	Date	Verification	n QC Inspector
Doc/Data											
quip/Tooling						1					
Operator											
Material		ļ.									
etup	_										
Other					,						
rocess	_										
Supplier											
raining											
Jnapproved						1					
					F	AULT CA	TEGORY				
Landin	g Gear			_	General				•		
	Bending				Bend	Gra	in		Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to	o/s	BOM/Route	Har	dware		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Insp	ection Incomplete		Part Incorre	ct .	Weld
	Crushed/	Crimped		L	Burrs	Inst	ructions Incomplete,	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
[Cuffs				Contamination	Ma	intenance		Part Moved		
	Heat Trea	at			Countersink	Mis	abeled	<u></u>	Positioned V	Vrong	
	Inspectio	n Strip in	Tube		Cut Too Short	Mis	read		Power Loss/	Surge	Other
[Ripples in	n Bend			Drill Holes	Offs	et				
[Torque W	Vaves in E	xtrusio	n [Drawing	Out	of Calibration				
	Turning S	equence			Finish -	Out	of Sequence				
	Wave/Tw	ist in Tul	oe		Folio	Out	side Dimensions				

Work Ord <i>May-13-13 1:0</i>		101508		*101				Page 2			
Item ID: Revision ID: Item Name:	D3219-1			Accept	*N900	040	100)* s	etup Star Stop	1.71	S1*
Start Date: Required Date Reference:	5/13/13	Start Qty: 140.00 Req'd Qty: 140.00	*140 [°] *140°		Cust Item I Customer:	D:					
Approvals:		Plan:	Date:			ate:		R	un Star Stop	"1/	R1* R2*
Sequence ID/ Work Center 130 *120* Small Fab Small Fab	ID	Operation Description Small Fab Memo 1-Deburr if no	A)/A	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*140 *140* QC Quality Control		QC5- Inspect part completed Memo	eness to step on W/O	0.00				NY			0AS 19 13.09.1

150

Identify as per dwg & Stock Location: 1003 0.00

150 Packaging

Memo

0.00

Packaging

*** STOCK IN STEP CELL***

		•
DQA:	Date:	· · · · · · · · · · · · · · · · · · ·

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

INCK. 1	es / No				WORK ORDER NON-	COM	FURI	MANCE / OPDATE		QA Closed:	Da	ate:	
Work Orde	r:				DISPOSITION			AGAIN	ST DE	PARTMENT,	/PROCESS		
Part N					Rework Scrap		N	Skid-tube Crosstu Machining Small F	ab	4	Water Jet		Engineering Quality
NCR N	0	-			Use-as-is Work Order Update]		noforming Finishi Large Fab Compos		Rec/Stol	re/Packaging Supplier	$\overline{}$	Other
Root				Descr	iption of work order update	Ini	itial	Action		Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Description		Date	Verificatio	n	QC Inspector
oc/Data quip/Tooling Operator												ļ	
Material													
etup	-	İ											
ther	_												
rocess													
upplier			1										
raining	7												
Inapproved		1											
						FAULT	CATEC	GORY					
Landin	ng Gear				General				_	•			
.	' Bendin	=			Bend	ļ	Grain		<u> </u>	Ovalized		\vdash	Pressure/Forced
	_	Not Conce	ntric to C	o/s	BOM/Route	-	lardwai			Over/Under		\vdash	Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged	\vdash	-	on Incomplete		Part Incorred		-	Weld
ļ		d/Crimped		-	Burrs	-		ions Incomplete/Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
	Cuffs			<u> </u>	Contamination		Nainte			Part Moved			
1	Heat Tr		•	.	Countersink	\vdash	/islabel			Positioned V	_		
		ion Strip in	1 Tube	<u> </u>	Cut Too Short	-	/lisread			Power Loss/	Surge	Ш	Other
,		in Bend			Drill Holes	\vdash	Offset						
-		Waves in		י 📙	Drawing	-		Calibration			_		
		Sequence		<u> </u>	Finish			equence					
	Wave/	wist in Tu	be		Folio)utside	Dimensions					

Work Ord <i>May-13-13 1:0</i>		101508		*101	508*							Page 3
Item ID: Revision ID: Item Name:	D3219-1			Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*
Start Date: Required Date Reference:	5/13/13 :: 5/31/13	Start Qty: 140.00 Req'd Qty: 140.00	*140 *140	-	Cust Item I Customer:	D:						
Approvals:	Process QC:	Plan:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	*NI *NI	R1* R2*
Sequence ID/ Work Center 1 160 *160* QC Quality Control	ID	Operation Description QC21- Final Inspection - Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	t Re Qt	-	Reject Number	Insp. Stamp

113-0a-14

										DQA:	Date	:
NCR: Y	es / No				WORK ORDER NON-	COI	NFOR	MANCE / UPDATE		0.4.61		
,									_	QA Closed:	Date	:
Mank Onda	<u></u>				DISPOSITION			AGAINST	DE	PARTMENT	PROCESS	
Work Orde	:I				Rework	7		Skid-tube Crosstube		1	Water Jet	Engineering
Part N	lo				Scrap	1		Machining Small Fab		Pro	d. Eng. Coor.	Quality
, are i					Use-as-is	1	•	noforming Finishing		4	e/Packaging	Other
NCR N	lo.				Work Order Update	1		Large Fab Composite			Supplier	
					,			·		.		
Root				Descri	ption of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty	,	or Non-conformance	Cł	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling						Ì						
Operator		İ										
Material	_	İ										
Setup							:					
Other						1						
Process	_							•				
Supplier		1										
Training	_					1						
Unapproved		<u> </u>	<u> </u>				T CATE	CORY				
1 di	6					AUI	LT CATE	GORY				
Landir i l	ng Gear Bending			_	General Bend		Grain	ſ		Ovalized		Pressure/Forced
	—	ot Conco	ntric to	0/5	BOM/Route	\vdash	Hardwa	ro		Over/Under	toloranco	Temperature/Cure
	Centre N Cracks	or conce	iitric to	∪/3 -	Broken/Damaged	-	4	on Incomplete		Part Incorrec		Weld
	Crushed/	Crimand		<u> </u>	Burrs	\vdash	-1	ions Incomplete/Unclear		Part Lost/Mis	<u> </u>	Wrong Stock Pulled
	Cuffs	Cimped		-	Contamination	-	Mainte	· ·		Part Moved	37118	Terrorie stock runed
	Heat Trea	at		-	Countersink		Mislabe			Positioned W	/rong	

Misread

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Page 1

Work Order ID:

101508

Parent Item:

D3219-1

Parent Item Name: Pla

Plate

Start Date: 5/13/13

Required Date: 5/31/13

Start Qty: 140.00

Required Qty: 140.00

Comments:

IPP A04.04.19New issueKJ/JLM

ESR B 06.05.25 Wateriet EC

	ESIC B 00.05.25													
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M6061T6S.125		Purchased	No			100	sf	187.9862	0.0964	14.206318	3		4.42 00	2
6061-T6 125 Sheet					*				C	<u></u>	٥	14449	THISO	1

Location	Loc Oty	Loc Code	
MAT021	187.9861578		****
121473	0.9161578		
123279	72.89		
125257	114.18		

126610.

126670

										DQA:	u	ate:	
NCR:	res / No				WORK ORDER NON-	COI	NFORI	MANCE / UPDATE		QA Closed:	D	ate:	
NAZ a mla O mala					DISPOSITION			AGAINS	r DE	PARTMENT	/PROCESS		
Work Orde	er:				Rework	1		Skid-tube Crosstube	\Box	1	Water Je		Engineering
Part N	lo.				Scrap	1	i .	Machining Small Fal	_	Pro	d. Eng. Coo	\rightarrow	Quality
raiti	.			*	Use-as-is	1	1	noforming Finishing	-	4	e/Packagin		Other
NCR N	No.				Work Order Update	1	'''	Large Fab Composite	_	1 1100,3101	Supplie		
,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,						J			· L			`Ш	
Root				Descri	ption of work order update	Π	Initial	Action		Sign &			
Cause	Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Description		Date	Verificati	on	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup													
Other													
Process				1 4				. 1					
Supplier	Ц							'					
Training	Ц			1									
Unapproved		<u> </u>								<u> </u>			
 -					,	AUL	T CATE	GORY					
Landi	ng Gear				General	_	٦		_	7			
	Bending			_	Bend		Grain		\vdash	Ovalized		\vdash	Pressure/Forced
	H	lot Conce	ntric to	o/s	BOM/Route	_	Hardwa		—	Over/Under		\vdash	Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged	\vdash	-	on Incomplete	\vdash	Part Incorred		-	Weld
	_	/Crimped		-	Burrs	_	4	ions Incomplete/Unclear	_	Part Lost/Mi	ssing	Ш	Wrong Stock Pulled
	Cuffs			1	Contamination	1	Mainte	enance	ı	Part Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

DART AEROSPACE LTD	Work Order:	101508
Description: Plate	Part Number:	D3219-1
Inspection Dwg: D3219 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article		Prototype
-----------------	--	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.316	+0.005/-0.000	0.317	-		v	de de constante de
2.293	+/-0.005	2-293"	-		ν	
2.965	+/-0.010	2.967"	-		· V	
0.566	+/-0.010	0:200,	_		J	
0.375	+/-0.010	0.3782			V	* 1
R0.125	+/-0.010	0.135,			20-	
13.9°	+/-0.5°	13.90	•-		Robade.	
						1
			DAS			

		27		
Measured by: Jm	Audited by:	9-89	Prototype Approval:	N/A
Date: 13-09-15	Date:	13-916	Date:	N/A

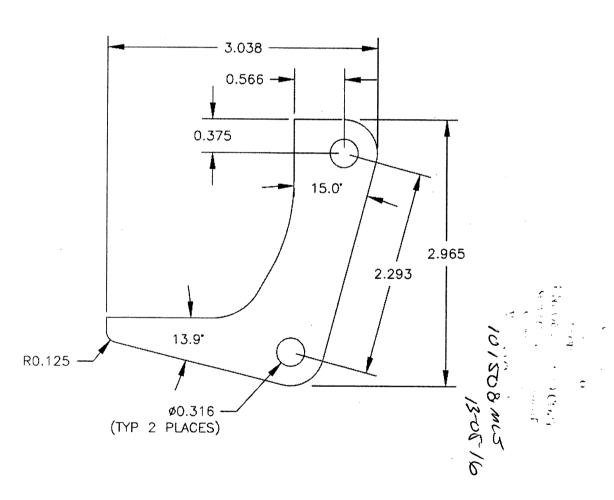
Revised by	Approved
KJ/JLM	1
KJ/JLM	
K I/DD	N
-	KJ/DD





DESIG	N A	DRAWN BY	1	AEROSPACE LTD	
CHEC	ŒD,	APPROVED .	DRAWING NO. D3219	SHEET	REV. A 1 OF 1
DATE			TITLE		SCALE
 03.1	0.10		PLATE		1:1
Α		03.10.10	NEW ISSUE		





D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRT"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11)
 - (REF DART SPEC M6061T6S.125)
- FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.